

# Work Order ID 107111

Friday, September 20, 2013 2:21:23 PM

\*107111\*

Ship Sept 27<sup>th</sup>  
Page 1

Item ID: D2170 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Bracket Assembly  
Start Date: 9/20/2013 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 9/27/2013 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: MF Date: 13-9-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2170	

100		0.00							
*100*	Small Fab					2x			
Small Fab	Memo	0.00							
Small Fab	1- Pick parts 2- Assemble as per Dwg								

110	QC5- Inspect part completeness to step on W/O	0.00	OAS 27 9-89						
*110*						2x			
QC	Memo	0.00	139.2						
Quality Control									

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*120*									
Powdercoat	Memo	0.00							
Powder Coating									

W126125

Start Time: 11:15  
Temp: 4000F  
Finish Time: 11:45  
2x PM 13/09/26

**Work Order ID 107111****\*107111\***

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Revision ID: Stop **\*NS2\***  
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Required Date: 9/27/2013 Req'd Qty: 2.00 **\*2\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>Ship</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

2x 4 13/09/26

2x 13-9-26

MS 13-09-26  
MS  
13-9-26

# Picklist Print

Friday, September 20, 2013 2:21:22 PM

Page 1

Work Order ID: 107111

Parent Item: D2170

Parent Item Name: Bracket Assembly

Start Date: 9/20/2013

Required Date: 9/27/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.09.18 NEW ISSUE DD VERF:JFS

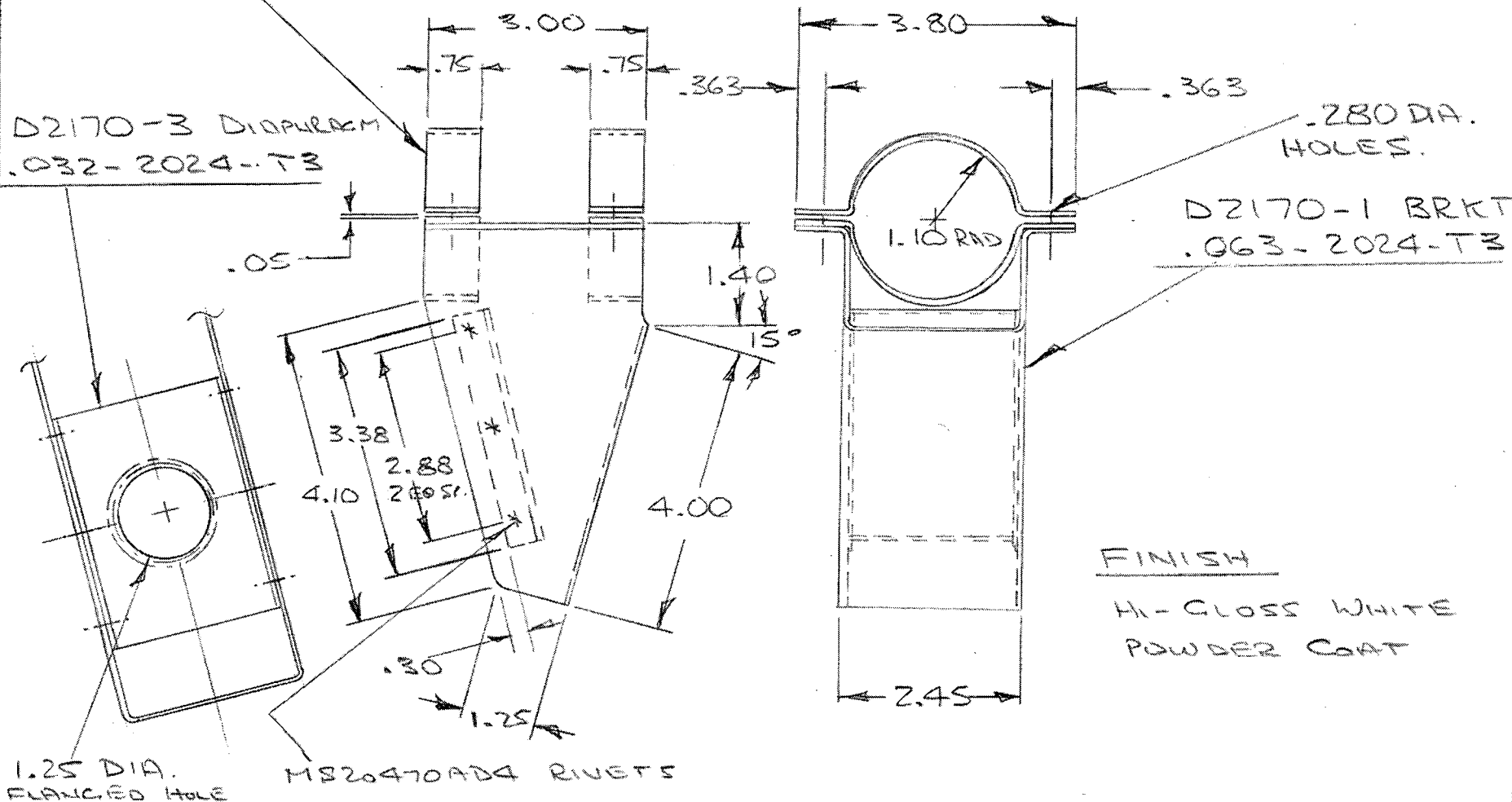
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2170-1 Bracket		Manufactured	No			100	Each	0.0000	1	2		9/13/09/25	
D2170-3 Bracket		Manufactured	No			100	Each	0.0000	1	2		9/13/09/25	
MS20470AD4-4 Rivet, Universal Head		Purchased	No			100	Each	5,286.0000	6	12		9/17/09/25	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		1							
				121652		1							
				ST336		5285							
				116188		68							
				118614		135							
				122027		188							
				m125807		1178							
				m126275		3716							
										12			

D2171 CLAMP (4)

.063 - 304 STAINLESS ST'L

D2170-3 DIAPHRAGM

.032 - 2024 - T3



FINISH

HI-GLOSS WHITE  
POWDER COAT

1.25 DIA.  
FLANGED HOLE

M820470AD4 RIVETS

REVISION		CONTRACT NO.		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA													
DRAWN		DESIGN: <i>Handwritten signature</i>		CLIENT													
APPROVED		DATE: 93-03-01		TITLE: STEP BRACKET DETAILS													
DESCRIPTION		STRESS		CODE													
OF		CHECKED		ENG NO: D2170/D2171													
CHANGE		CLIENT		REV.													
<p>REQUIREMENTS - UNLESS OTHERWISE SPECIFIED</p> <table border="1"> <thead> <tr> <th>GENERAL</th> <th>LIMITS</th> </tr> </thead> <tbody> <tr> <td>1. DIMENSIONS ARE IN INCHES</td> <td>1. TOLERANCES - .001</td> </tr> <tr> <td>2. SURFACE ROUGHNESS 125</td> <td>2. ANGLES 1.00</td> </tr> <tr> <td>3. REMOVE SHARP EDGES .015 MAX</td> <td>3. PARALLELISM .002</td> </tr> <tr> <td>4. THREADS PER MIL - 9 - 7742</td> <td>4. PERPENDICULARITY .005 MAX</td> </tr> <tr> <td>5. Holes PER AND 10387</td> <td>5. SYMMETRY AND 10387</td> </tr> </tbody> </table>		GENERAL	LIMITS	1. DIMENSIONS ARE IN INCHES	1. TOLERANCES - .001	2. SURFACE ROUGHNESS 125	2. ANGLES 1.00	3. REMOVE SHARP EDGES .015 MAX	3. PARALLELISM .002	4. THREADS PER MIL - 9 - 7742	4. PERPENDICULARITY .005 MAX	5. Holes PER AND 10387	5. SYMMETRY AND 10387	<p>ALL M/C CENTER LINE .010</p>		<p>SCALE: NTS</p>	
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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